



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW5305G81851-3G
Job Sheet 184933



5243
moved to Nov 29

Part No: RBW5305G81851-3G

Job Qty: 2 ea

Part Name: T/B Lift Fittings (Includes Left & Right Bracket)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/18/18

Job Tracking No:

Due Date: 11/1/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW5305G81851-3G REV 1D IPP REV A 18.05.28 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	11/1/18	11/1/18	0.00	0.00	Start Up Small Fab-2		MLC
110	Small Fab	2 pcs	11/1/18	11/1/18	0.00	2.00	Small Fab-3		MLC
120	QC	2 pcs	11/1/18	11/1/18	0.00	0.00	QC5		BAS 30
130	Packaging	2 pcs	11/1/18	11/1/18	0.00	0.00	Packaging3-1		MLC 9.89
140	QC21-FG	2 Ea	11/1/18	11/1/18	0.00	0.00	QC21		MLC 9.89

Part Op 110 - 1-Pick kit as per DWG
Descriptions:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW5305G81851-3G-1	Right Weldment	2 Ea (1 ea)	90-Start up Operation	5137360
RBW5305G81851-3G-7	Left Weldment	2 Ea (1 ea)	90-Start up Operation	5137362

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBW5305G81851-3G-1 LF	2	0	0
	RBW5305G81851-3G-7 LF	2	0	0

Part Specifications

Specifications could not be found.



Container No: S140666



Part: RBW5305G81851-3G

Job No: 184933

Serial No/Batch: S140666

Revision: B

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

1/18/18 11:28 AM Dart.lajeunesse.marie

Date: 12/29/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐			
--	--	--	--	--	--

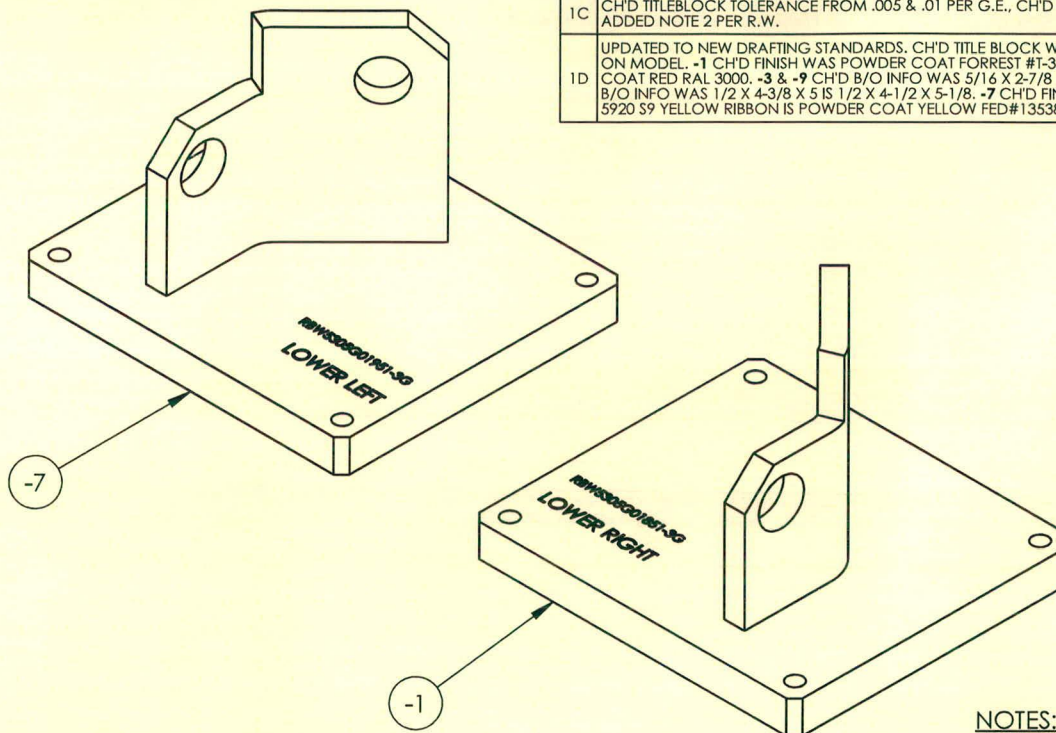
Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
--------	---------	-----------------	-----------------------

Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :					
Misidentified ☐	Past Due ☐						

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	ROUNDED MOST TOLERANCES UP TO .01 PER DAVE.	5/19/2010	WP	DW
1	ADDED -3G TO TOOL NUMBER. DELETED CHAMFERS -3 & -9 PER DW. ADDED MACHINE ENGRAVE NOTE -5 PER RW.	4/8/2011	RJC	
1A	DELETED -3 THRU, FAR SIDE & CHAMFER FROM Ø.69 HOLE.	10/10/2011	RJC	
1B	CORRECT P.N. WAS RBW5385G81851-3G, ADDED P.N. ONTO PLATE FOR ENGRAVING.	3/6/2012	SE	RW
1C	CH'D TITLEBLOCK TOLERANCE FROM .005 & .01 PER G.E., CH'D -5 .44 TO (.50) DIMENSION AND ADDED NOTE 2 PER R.W.	4/4/2012	RJC	RW
1D	UPDATED TO NEW DRAFTING STANDARDS. CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED USED ON MODEL. -1 CH'D FINISH WAS POWDER COAT FORREST #T-3370 S9 RED WAGON IS POWDER COAT RED RAL 3000. -3 & -9 CH'D B/O INFO WAS 5/16 X 2-7/8 X 3-1/2 IS 5/16 X 3 X 3-3/4. -5 CH'D B/O INFO WAS 1/2 X 4-3/8 X 5 IS 1/2 X 4-1/2 X 5-1/8. -7 CH'D FINISH WAS POWDER COAT FORREST #T-5920 S9 YELLOW RIBBON IS POWDER COAT YELLOW FED#13538.	7/2/2014	DPD	RJC



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 184933 M65
1870-18

NOTES:

1. LEFT WELDMENT MIRRORS RIGHT WELDMENT.
2. PART OF KIT RBW5305G00131-3G.
3. LOAD TEST EACH WELDMENT AT 750 - 800 LBS.
4. REF. AGUSTA T/N: 3G5305G81851.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	RIGHT WELDMENT			2
	1		-3		RIGHT TAB	1018	5/16 X 3 X 3-3/4	3
1	1		-5		PLATE	1018	1/2 X 4-1/2 X 5-1/8	4
X			-7	1	LEFT WELDMENT			5
1			-9		LEFT TAB	1018	5/16 X 3 X 3-3/4	6
4	4	B/O	-11		HEX HEAD BOLT	STEEL	AN3-17A AIRCRAFT SPRUCE	NS
4	4	B/O	-13		FLAT WASHER	STEEL	AN960-10 AIRCRAFT SPRUCE	NS
ASSY -7	ASSY -1							

DART AEROSPACE	
T/B LIFT FITTINGS	
TITLE	REV 1D
DWG NO.	RBW5305G81851-3G
MAT'L	DRAWN BY: DUERFELDT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weill</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AW139
SCALE 1:2	DATE 7/2/2014
SHEET 1 OF 6	



184939

Proof Load Capacity Test

Part Number

Revision

Serial Number

Date

RBW5305G81851-3G-1

1D

S137360

2018 DEC 21

Proof Load Capacity

800

LBS

Tested By:

ALAN PATRY

Technician

Approval: _____

Position: _____

QC 5 Small FAB / QA



Proof Load Capacity Test

Part Number

Revision

Serial Number

Date

RBW5305G81851-3G-1

1D

S137360

2018 DEC 21

Proof Load Capacity

800

LBS

Tested By:

ALAN PATRY

Technician

Approval: _____

Position: _____

QC 5 Small FAB / QA